

Work Order ID 82902

82902

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April-10-12 2:43:36 PM

Item ID: D206-559-013

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Bearpaw

Stop *NS2*

Start Date: 10/04/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 12/04/10 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D206-559

rev L

100

100

DOCUMENT CONTROL

0.00

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-559-013 CHG006

Scrkstcr

M.L.J 12/05/01

160

Pick Kit

0.00

160

Packaging

Memo

0.00

Packaging

(10)

12/5/10

SP

170

QC4- 100% Inspect kits for completeness

0.00

170

QC

Memo

0.00

Quality Control

Scrkstcr

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D206-559-013

Accept

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Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw

Start Date: 10/04/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

180

Packaging

Packaging

Memo

0.00

0.00

Packaging

Identify and pack for shipping as per PPPD206-559-013 Location: 2

190

190

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

MLJ 12/05/02

MLJ 12/05/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Work Order ID: 82902

82902

Parent Item: D206-559-013

D206-559-013

Parent Item Name: Bearpaw

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:J04.02.17Blank size changedKJ/JLM

IPP Rev:K 07-01-02 Was K10008 JLM

IPP Rev:L 08-01-09 Added Step 2 JLM Verified By:EC

IPP Rev:M 08-04-29 update seq. 8 and 12 DD verified by:EC

IPP Rev:N 08-10-15 New Manufacturing Method JLM Verified

By:EC IPP Rev G 10.10.04 per DSI9527 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-17A		Purchased	No			160	Each	490.0000	120	120			

S-40 Bolt *AN4-17A*

Location	Loc Qty	Loc Code
ST358	16	
116419	16	
116704	0	
ST359	474	
112314	0	
118983	74	
121011	200	
121068	200	

AN4-20A

Purchased No

160 Each

470.0000

120

S-40 Bolt *AN4-20A*

Location	Loc Qty	Loc Code
GA	50	
116419	50	
ST359	420	
117514	51	
119127	169	
121060	200	



**

16

SP



**

12/1/12

SP

99
121

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 82902

82902

Parent Item: D206-559-013

D206-559-013

Parent Item Name: Bearpaw

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 10.00

Required Qty: 10.00

AN960JD416 NAS1149D0463J Purchased No

160 Each

10.0000

24 240

AN960JD416

Washer

**

M121205/02

Location

Loc Qty

Loc Code

ST351

10

116289

10

D2182B Manufactured No

160

f

280.5342

2.5

25

D2182B

Rubber Cushion

**

J B 12/05/02

Location

Loc Qty

Loc Code

ST410

280.53417

63413

1.6

66063

41.61817

73932

237.316

73932

(D2182B050) cut qty (6) at 5.00" as per dwg ***per kit***

D2274

Manufactured No

160

Each

442.0000

12

120

D2274

Radius Block

**

Location

Loc Qty

Loc Code

ST007

442

78233

42

81958

400

D2432

Manufactured No

160

Each

2.0000

2

20

D2432

206 (24") Bearpaw

**

120 19x B82909

Location

Loc Qty

Loc Code

ST499

2

81044

2

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 82902

Parent Item: D206-559-013

Parent Item Name: Bearpaw

82902

D206-559-013

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 10.00

Required Qty: 10.00

D2438

Manufactured No

160 Each

10.0000

D2438

Clamp

** 6 60 36x
B81966

24x
B832655

Location

Loc Qty

Loc Code

ST456

10

77038

6

81486

4

D2529

Manufactured No

160 Each

459.0000

D2529

Washer

** 12 120 100x
B83544

JB 8/12/05/02

Location

Loc Qty

Loc Code

ST010

459

79485

18

81873

441

D2732

Manufactured No

160 f

153.1353

D2732

Rubber Extrusion

** 2.5 25 20x

JB 8/12/05/02

Location

Loc Qty

Loc Code

ST410

153.135299

70987

153.135299

70987

(D2732:050) cut qty (6) at 5.00" as per dwg ***per kit***

MS21042L4

Purchased No

160 Each

4,000.000

MS21042L4

Nut

** 12 120 12/5/05

JB 8/12/05/02

Location

Loc Qty

Loc Code

ST300

4000

119017

4

119075

1996

121011

2000

20

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Shop Packet Print

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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REFERENCE ONLY

DART AEROSPACE LTD.

D206-559
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5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			16	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						8	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						8	D4011-1	CLAMP, SHORT
						8	D4011-5	CLAMP, SHORT (OEM)
						8	D4012-1	CUSHION
						2	D4355-1	BEARPAW
						2	D4360-041	WEARPLATE ASSEMBLY
						8	AN4C11A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
8	12	8	12	8	12		AN4-20A	BOLT
						16	AN4C20A	BOLT
						16	AN4C21A	BOLT
16	24	16	24	8	12	16	NAS1149D0463J	WASHER (OR AN960JD416)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						24	MS21043-4	NUT
2		2					QS200M44S	CLAMP

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Date: 11.04.08